Work Orde September-18-12		<u> </u>	*902	191*	٠					Page 1
Revision ID:	647.0410 Tube		Accept	*N900	040	100)* 5	Setup Star	ı VI -	S1* S2*
Start Date: Required Date: (Reference:	18/09/2012 Start Qty: 10.00 02/10/2012 Req'd Qty: 10.00	1 \ 7		Cust Item II Customer:	D:					
	Process Plan: MLJ QC:	-			ite:		I	Run Star , Stop) IN	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
647.0400	N/C							•		
*110 *110* Small Fab Small Fab		S PER DWG RR AS PER DWG	0.00		-		-10	Þ		FF 12-09-
*120 *170* QC Quality Control	QC6- Inspect dimensio	ons to drawing	0.00 OAS 0.00 16 9-5	Modro			- (HE	e)——		
130 *130* Outsource4	Outsource process-And	odize per QSI017 4.1.10.1	0.00	70'-1864				1212	1 <u>10/e</u>	02.0

0.00

Memo

Outsource process - Anodize

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONFORM	MANCE / UF	PDATE	QA Closed:	Date:	
Moule Oud a					DISPOSITION			AGAINST DE			
Work Orde Part N				· · · · · · · · · · · · · · · · · · ·	Rework Scrap]	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N					Use-as-is Work Order Update	4 1	noforming Large Fab	Finishing Composite	1	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator											
Material											
Setup											
Other											
Process		1				ů.					
Supplier											
Training								•		·	
Jnapproved			<u> </u>						<u> </u>		<u> </u>
						AULT CATE	GORY	·			
Landin	g Gear			_	General				1	· -	1
ŀ	Bending	-1.6		2/6	Bend BOAA/Bouts	Grain		<u> </u>	Ovalized Over/Under	<u> </u>	Pressure/Forced
}	Crasks	ot Conce	ntric to	J/\$ -	BOM/Route	Hardwa		<u> </u>	Part Incorre	-	Temperature/Cure Weld
. }	Cracks Crushed/	Crimnod		-	Broken/Damaged Burrs	\mathbf{H}	ion Incomplete tions Incomplete	/Unclear	Part Income		Wrong Stock Pulled
}	Cuffs	стпрец		<u> </u>	Contamination	Mainte	·	, onciear	Part Moved		I wrong stock runeu
•	Heat Trea	at			Countersink	Mislabe		• •	Positioned \		
F	Inspectio		Tube		Cut Too Short	Misread		<u> </u>	Power Loss,		Other
E .		~ · · · · · · · · · · · · · · · · · ·					-	L.		J- 1	

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Spray Painting

PRIME AS PER DWG BATCH: 123693

Page 2 September-18-12 3:24:46 PM Item ID: 647.0410 Accept *N900040100* Setup Start **Revision ID:** Item Name: Tube Start Date: 18/09/2012 **Start Qty: 10.00** *10* **Cust Item ID: Required Date:** 02/10/2012 Reg'd Otv: 10.00 *10* **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Oty Stamp Number 140 Receive & Inspect for Damage & Mat'l Certs 0.00 *110* Packaging 0.00 Memo Packaging 150 QC5- Inspect part completeness to step on W/O *150* QC Memo Quality Control 160 0.00 *160* SprayPaint 0.00 Memo

										•	DQA:	Date:	
NCR:	Yes /	No		÷		WORK ORDER NON-C	ONFO	RMA	ICE / UP[DATE	QA Closed:	Date:	
							<u> </u>						·
Work Ord	er:					DISPOSITION	i			AGAINST DE	EPARTMENT,	/PROCESS	
Part f						Rework Scrap		Mach	-tube	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No					Use-as-is Work Order Update	The	ermofor Larg	e Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initia		Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief E	ng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
опаррточеа				l	<u>L</u> .		AULT CA	TEGOR	<u> </u>			L	<u> </u>
Landi	ing Gea				-	General							
	Be Ce Cr Cr Cu	ending entre No racks ushed/O uffs eat Trea	ot Concer Crimped t n Strip in		O/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Insp Instr Mai Misl Misr	lware ection In ructions ntenani abeled read	ncomplete Incomplete/U	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned \ Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ri	pples in	Bend		1	Drill Holes	Offs	et					

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

•														
Work Ord September-18-1				* * * * * * * * * * * * * * * * * * *	*904	L91*							Page 3	
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	647.0410 Tube 18/09/2012 02/10/2012	Start Qty: 10.00 Req'd Qty: 10.00		*10* *10*	Accept	*N900 Cust Item I Customer:		100)*	Setup	Start	I VI	S1* S2*	
Approvals:	Process Pla	n:					ate:			Run	Start Stop	!//	R1* R2*	
Sequence ID/ Work Center II 170 *170* QC Quality Control	D	Operation Description QC14- Inspect Spray Pain Memo	t		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty	ject y	Reject Number	Insp. Stamp AS 05 12-16	9-18
*180 *180* Packaging Packaging		Identify as per dwg & Stor	ck Location	1 <u>./39</u> A	0.00					10/3	\o ₁ p		(0)	

190

QC21- Final Inspection - Work Order Release

0.00

190

Memo

0.00

13/1/10 des mr 13-01-09

Quality Control

			DO 4 :	0-4	
			DQA:	Date:	_
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

	cs / 110		,		Work on En Hor			5.112	QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet	Engineering Quality
NCR N	0				Use-as-is Work Order Update	Ine	rmoforming Large Fab	Finishing	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
equip/Tooling											
Operator											
Material											
Setup						ì					
Other											
Process							,				
Supplier											
Training							İ				
Unapproved											
					FA	AULT CA	regory				
Landin	g Gear				General				_		
<u>[</u>	Bending				Bend	Grai	1		Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
ŀ	Crushed/	Crimped.			Burrs	Instr	ictions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	ntenance		Part Moved		
	Heat Trea	nt			Countersink	Misla	beled		Positioned V	Vrong	
	Inspection	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offse	t				
[Torque W	/aves in E	extrusion	ı ·	Drawing	Out	of Calibration				
[Turning S	equence			Finish	Out	of Sequence				
	. Wave/Tw	ist in Tub	e		Folio	Outs	de Dimensions				

Picklist Print

September-18-12 3:24:50 PM

Work Order ID: 90491

647.0410

Parent Item Name: Tube

647 0410

Start Date: 18/09/2012

Required Date: 02/10/2012

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

Parent Item:

IPP REV:A 12.09.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.035		Purchased	No			110	f	12.0000	0.4275	4.5	,		
MGOG1TG	T1 000	M 025	•						**	(IN)	(F)		

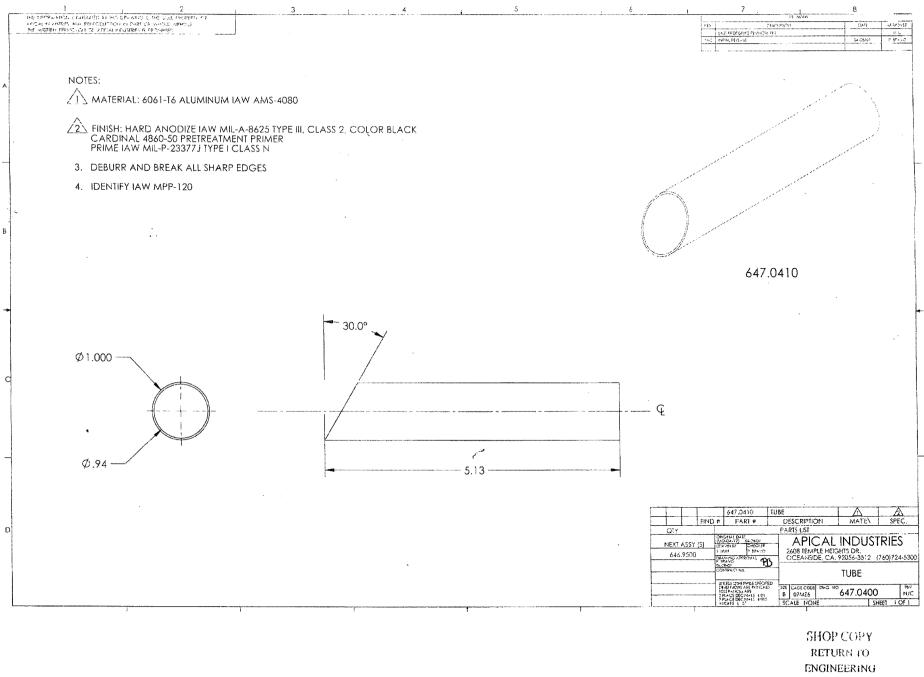
6061-T6 ROUND TUBE 1" X .035" WALL

Loc Qty Location Loc Code MAT035 12 123010 12

		DQA:	Date:	
	•	-		
ICR: Vos / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

										QA Closed:	Date:	
Work Orde	ır.				54	DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N	lo					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	D	ate	Step	Qty		or Non-conformance	Chief Eng	Descr	ription .	Date	Verification	QC Inspector
Doc/Data			· ·								-	
Equip/Tooling												
Operator												
Material												
Setup												
Other		İ										
Process												
Supplier								1				
Training		ı										
Unapproved												
						, F	AULT CATE	GORY				
Landir	ng Gear					General			_	1		-
	_	iding				Bend	Grain	•		Ovalized		Pressure/Forced
			Concer	itric to (o/s	BOM/Route	Hardwa		<u></u>	Over/Under		Temperature/Cure
	Cra					Broken/Damaged	—	ion Incomplete		Part Incorre	ct	Weld
			rimped.			Burrs		tions Incomplete/I	Unclear	Part Lost/Mi	issin(Z 🕵 🗀	Wrong Stock Pulled
	Cuf				_	Contamination	Mainte			Part Moved	123 123	
		t Treat			_	Countersink	Mislabe		ļ	Positioned V	M6061T61.000W.035	ا .
			Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge O O	Other
		ples in E			<u> </u>	Drill Holes	Offset			*		
	_	•	ives in E	xtrusio	٦	Drawing	 	Calibration				
			quence			Finish	\blacksquare	Sequence			<u></u>	
	Wa	ve/Twis	st in Tub	e		Folio	Outside	Dimensions			ŭ	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 90491 MCT 12-09-19

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:	·	-			DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
Part No.	-				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	ł	Water Jet	Engineering Quality
NCR No.				<i></i>	Use-as-is Work Order Update						
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator						<u> </u>					
Material		ļ									
Setup							•				
Other]										
Process											
Supplier	7						}		1		
Training	1	1	Ì								

Positioned Wrong Mislabeled Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

FAULT CATEGORY

Grain

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Over/Under tolerance

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Broken/Damaged

Unapproved

Landing Gear

Bending

Cracks

Cuffs

Crushed/Crimped.

Centre Not Concentric to O/S

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18042

Purchase Order Date 10/02/12 PO Print Date 10/02/12

Page Number 1 of 1

Order From:

VC-ATG001

A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE ROAD ROCKLAND, ON K4K 1T2 **CANADA**

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30 CAD

Currency **FOB**

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Line Nbr Reference Description/ Req Date/ Req Qty/ Ship Method **Unit Price** Extended Mfg ID Revision ID Taxable Unit of Measure Price Vendor Part Number 90491 647.0410 TUBE 10/05/12 10.00 FedEx PI collect \$11.0000 \$110.00 Yes

Special Inst:

BLACK ANODIZE AS PER DWG 647.0410

B90491

FINISH; HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2,

COLOR BLACK

PO Total:

\$110.00

CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required -YES NO

Change Nbr:

Change Date: 10/02/12



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List
Number: 61966 Date: 04-001-12

То

DART AEROSPACELTD 1270 ABERDEEN ST HAWKESBURY ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST-HAWKESBURY, ON, K6A-1K7 Canada

Ph: 613-632-5200

Ph: 613-632-5	200 Fax: 613-632-1185	Ph: 613-632-5	5200 Fax: 613-632-1	185
Terms	and the second s	Ship Via	A Section 1	30 - C. 27
Quantity	Description			
1	1. 4.0. 0110410	Rev:		
lot	10 PCS HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2	_		
	MINIMUM RUN Job: 20120600	PO: PO18042	Line:	
	Certificate of Con A.T.G. Industries certifies that all items with all requirements, specifications and	in this shipment are in conformance	order.	
	ISO 9001 : 2008 REG ATG SALES-2010 TE DATE : 4/10/12	SISTERED RMS APPLY		·
	CERTIFIED SIGNATURE :	<u> </u>		
·	RECEIVER SIGNATURE :			
·	i e se mani	•		
·	·			÷